

Date: Tuesday, 4/17/2007 3:09:02 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : CYCLIC GRIP/STICK OPTION C
Job Number : 31939	
Estimate Number : 12829	
P.O. Number : <i>N/A</i>	Part Number : P107
This Issue : 4/17/2007 S.O. No. : <i>N/A</i>	Drawing Number : GA122 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision : A
Previous Run :	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 4/24/2007 Qty: 1 Um: Each
Checked & Approved By : <i>[Signature]</i> 07.04.17	
Comment : Est Rev:A New Issue 07-04-16 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL
 Photocopy bluefile & type labels per PPP P107

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
 Pick Packing Kit

3.0	332A27 2114 21 ✓	BOOT
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 BOOT
 Batch: M103779- X

4.0	3410 14	Split Ring
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
 Split Ring
 Batch: M103779- X

5.0	341A27 1368 20W	BOOT
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 BOOT
 Batch: M103779- X

[Signature] 07/04/18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #:

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Description :

6.0

350A27 1185 00

PEDAL



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

PEDAL

Batch: M103882- X

7.0

350A27 1185 01

PEDAL, DIRECTIONAL CONTROL



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

PEDAL, DIRECTIONAL CONTROL

Batch: M103779- X

8.0

350A27 1328 01

PLATE, BOOT MOUNT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

PLATE, BOOT MOUNT

Batch: M103779 X

9.0

350A27 1340 20

COPILOT GRIP ASSEMBLY



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

COPILOT GRIP ASSEMBLY

Batch: M103779- X

10.0

350A27 1375 00 97

COVER, PITCH STICK



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

COVER, PITCH STICK

Batch: M103779- X

11.0

350A27 1375 20

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Screw

Batch: M103779- X

12.0

350A27 1376 20

Bushing, Tapped



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bushing, Tapped

Batch: M103779- X

C/Son/04/18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Part Number: P107

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

350A27 1525 0101

COLLERETTE FLANGE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

COLLERETTE FLANGE

Batch: M103779-

X

14.0

350A27 1528 0101

SHIM



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

SHIM

Batch: M103779-

X

15.0

A0023C06R35NW

PIN, LOCKING



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

PIN, LOCKING

Batch: M103779-

X

16.0

ASNA0033 045

Clamp



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Clamp

Batch: M103779-

X

17.0

G10201

Collective Stick



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Collective Stick

Batch: B31945-

X

18.0

G10202

CYCLIC STICK



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

CYCLIC STICK

Batch: B31943

X

19.0

G10204

Replacement Cyclic Grip



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Replacement Cyclic Grip

Batch: M104131-

X

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: DR Date: 07/04/18
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Machine Or Operation:

Description :

20.0

MS3116E20 41P

Connector, 41 pin



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Connector, 41 pin

Batch: M103779 -

X

21.0

GA10205

Co-pilot Ext.



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Co-pilot Ext.

Batch: B31944 -

X

07/04/18

22.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

U 07-04-18 C 07/04/18 (1)

23.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP P107

Location:

PPP Rev:

U 07/04/18

24.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/04/18 (1)

Job Completion



U 07-04-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

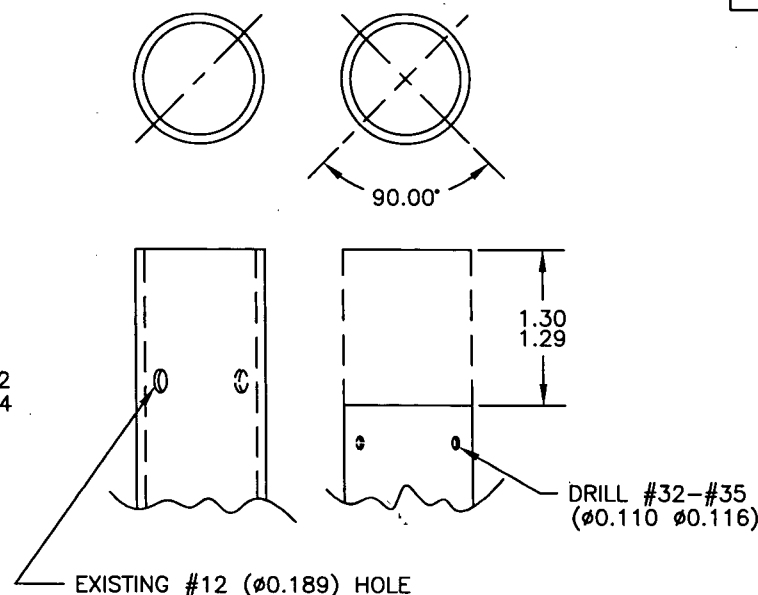
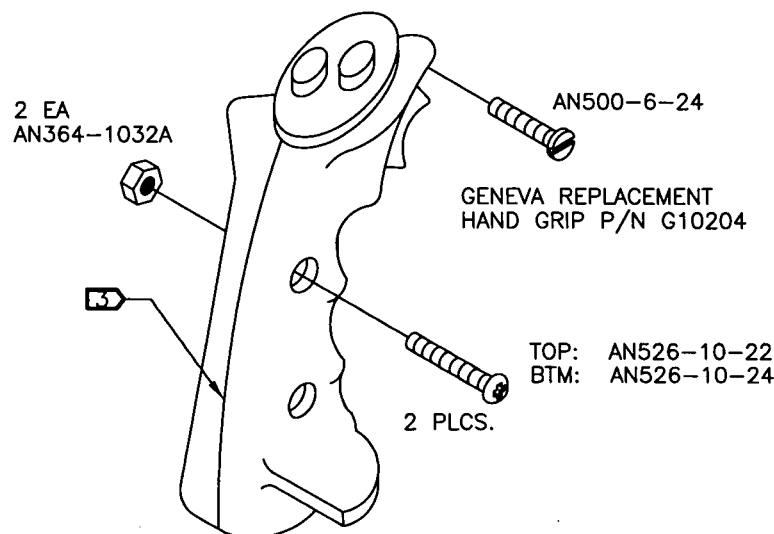
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

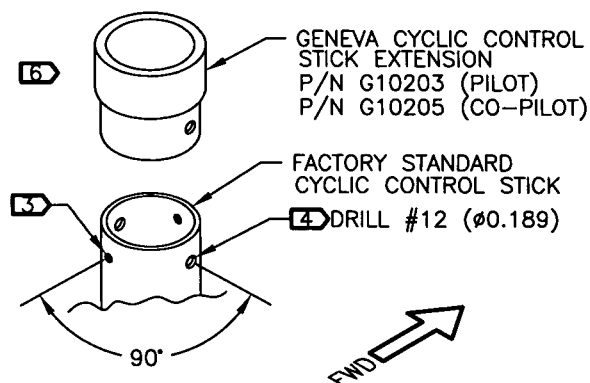
NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31934

REVISIONS		
REV	DESCRIPTION	APPROVAL/DATE
A	REDRAWN; COMBINED SHEETS 1 & 2	5/30/03 CLB



5 OPTION B: ALTERATION OF P/N G10202




OPTIONS A & D: ALTERATION OF FACTORY STANDARD CYCLIC CONTROL STICK

5 WHEN INSTALLING THE FACTORY STANDARD HAND GRIPS ONTO A GENEVA REPLACEMENT CYCLIC STICK, IT IS NECESSARY TO SHORTEN THE CONTROL STICK BY 1.3". BEFORE SHORTENING THE STICK, MARK THE LOCATION OF THE 0.11" DIA. HOLE USING THE EXISTING #12 HOLE AS A REFERENCE. THIS IS IMPORTANT TO GET THE PROPER ORIENTATION OF THE HAND GRIP. CLEAN AND DEBURR AFTER CUTTING DRILLING.

6 EXTENSION REQUIRED WHEN INSTALLING THE GENEVA HAND GRIP ONTO FACTORY STANDARD CYCLIC CONTROL STICKS. NOTE: DIFFERENT LENGTHS REQUIRED FOR PILOT AND CO-PILOT SIDES.

NOTES:

- OPTIONAL: TEXT MAY BE ENGRAVED, STAMPED OR PRINTED ON PART AS DESIRED
2. FOR CLARIFICATION, SEE GA122-1, INSTALLATION INSTRUCTIONS. OPTIONS INCLUDE:
- A. INSTALL P/N G10204 HAND GRIP ONTO FACTORY STANDARD CYCLIC CONTROL STICK.
 - B. INSTALL GENEVA CO-PILOT CONTROLS WITH FACTORY STANDARD CYCLIC CONTROL HAND GRIP.
 - C. INSTALL GENEVA CO-PILOT CONTROLS WITH GENEVA CYCLIC CONTROL HAND GRIP.
 - D. INSTALL GENEVA CO-PILOT CONTROL WITH GENEVA CYCLIC CONTROL HAND GRIP AND INSTALL GENEVA CYCLIC CONTROL HAND GRIP ONTO FACTORY STANDARD CYCLIC STICK ON PILOT SIDE.
- 3 4** WHEN INSTALLING OPTIONS A OR D (P/N G10204) ONTO FACTORY CYCLIC STICK, ALIGN THE SEAM (3) OF THE HAND GRIP WITH THE EXISTING MOUNTING HOLE (3) AND MATCH DRILL CYCLIC STICK, EXTENSION (4) TO LOWER MOUNTING HOLE ON HAND GRIP.

BREAK SHARP EDGES UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	DESIGNED CLB	DATE 5/30/03	 Geneva Aviation www.GenevaAviation.com
TOLERANCES ARE: FRACTIONS DECIMAL ANGLES ±1/16" X ±.005 ±.01"	DRAWN	DATE	
	CHECKED	DATE	
	APPROVED GLH	DATE 5/30/03	
THIS DOCUMENT INCLUDES INFORMATION PROPRIETARY TO GENEVA AVIATION AND SHALL NOT BE USED OR DUPLICATED BY ANYONE WITHOUT THE WRITTEN PERMISSION OF GENEVA AVIATION, INC.			Title INSTALLATION CYCLIC HAND GRIP
Drawing Number GA122-10		REV A	Sheet 1 of 1

